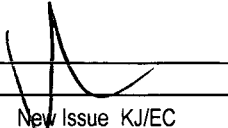


Grey

Dart Aerospace Ltd.

Date: Tuesday, 10/03/2009 10:04:08 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 46370	
Estimate Number : 10621	
P.O. Number :	Part Number : D34603
This Issue : 10/03/2009 S.O. No. :	Drawing Number : D3460 / D2577
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A / E
Previous Run : 46370	Material :
Written By : 	Due Date : 17/03/2009 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est: A 05.10.20 New Issue KJ/EC Est: B 06.03.01 Removed joggle on end EC Est Rev: C 09-03-10 now made on waterjet DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M1010S16GA	1010/1025 sheet 16GA
-----	------------	----------------------



Comment: Qty.: 0.8353 sf(s)/Unit Total : 3.3411 sf(s)
1010/1025 sheet 16GA
batch: 105706 B 9-3-12

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
1-Cut as per Dwg D3460/D2577 (use prog. D2577-101) E
Dwg Rev: E B 9-3-12 09.03.12

2-Deburr if necessary B 9-3-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1- Form on brake using DT8155 and DT8179 as per Dwg D2577 Rev: E
2- Form Detail "A" joggle using DT8157 as per Dwg D3460 Rev: A
Identify as D3460-3

SB 09/03/16
SB 09/03/16

④
④

Date: Tuesday, 10/03/2009 10:04:09 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 46370

Part Number: D34603

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/16 (x4)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D3460 Rev: A

Qty Part Number Description

Batch

A/R N/A

7560 Hardcoat Rod

M109560

EL 9-3-17 (x4)

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/03/17 (x4)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M109648

START TIME:

8:45

OVEN TEMPERATURE:

320°

FINISH TIME:

9:15

BL 09-03-20 (x4)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-20 (x4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 499

S 09/03/20 (x4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24 (x4)

Job Completion



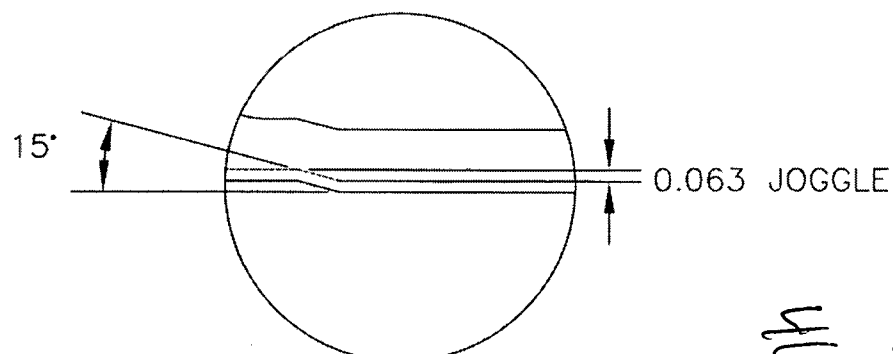
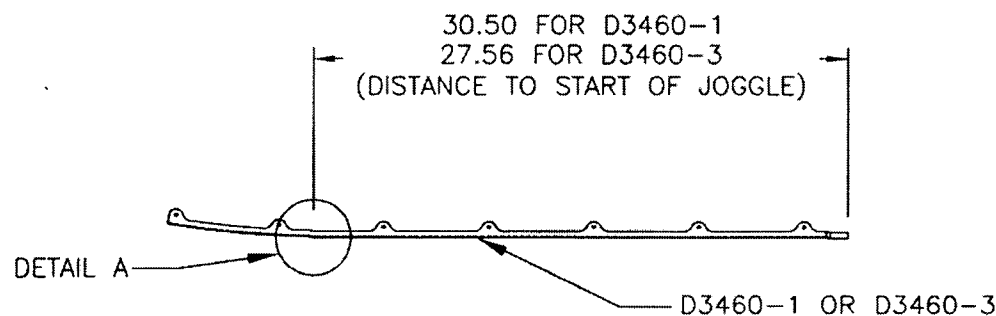
mf 09-03-23

DART

RELEASED
8 JUL 14

DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	05.10.04	DRAWING NO.	D3460	REV. A
		TITLE	WEARSHOE	SHEET 1 OF 1
A		05.10.04	NEW ISSUE	SCALE 1:10

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



46370
210

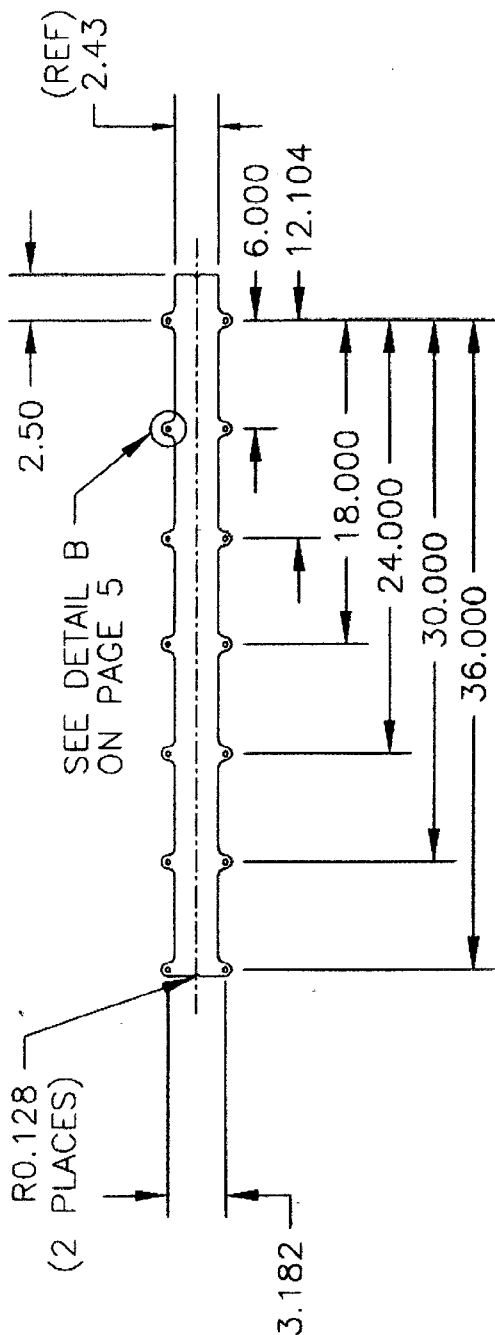
D3460-1/-3 WEARSHOE

- 1) MAKE D3460-1 FROM D2577-11 LONGITUDINAL BEND
- 2) MAKE D3460-3 FROM D2577-13 LONGITUDINAL BEND
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



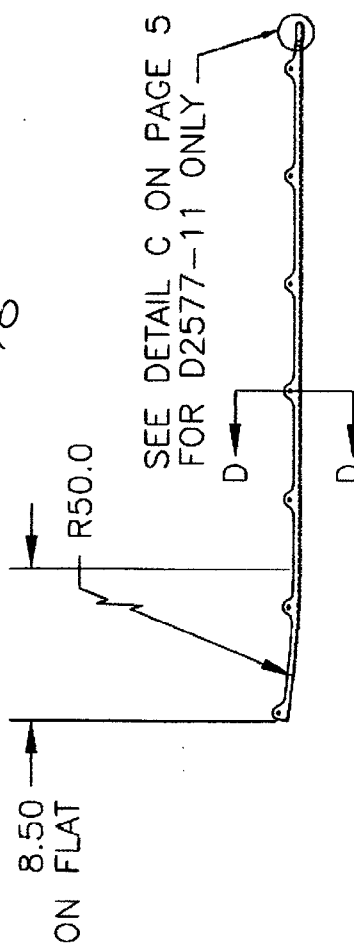
DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 2 OF 5
DATE 00.09.22	TITLE WEARSHOE	SCALE 1:10	

RELEASED
00.09.22 #



D2577-101 FLAT PATTERN
BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570
SERIES STEEL 0.063 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

46376



D2577-11 & D2577-13 LONGITUDINAL BEND
MAKE FROM D2577-101
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

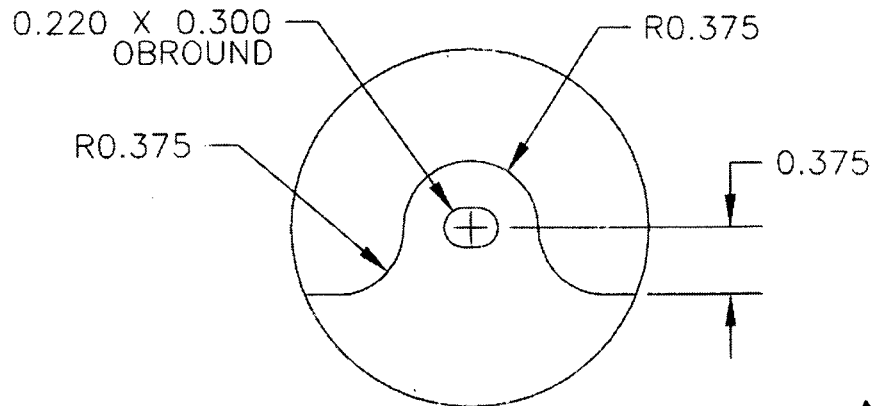
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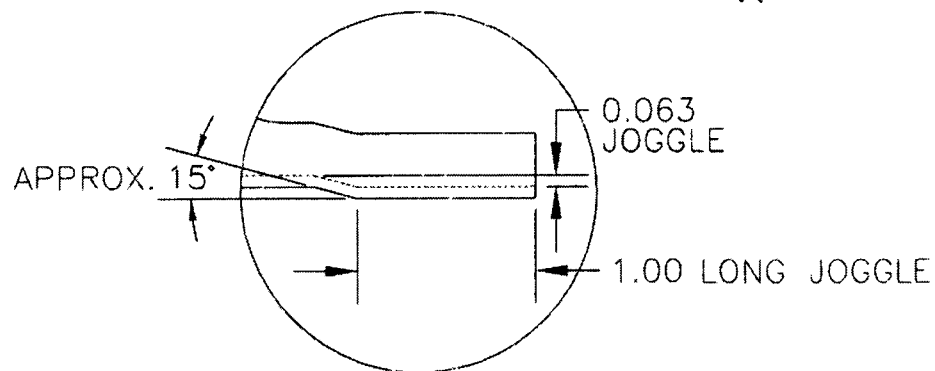


DESIGN [Signature]	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

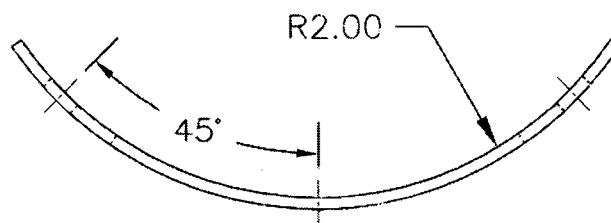
DETAIL B (SCALE 1:1)



DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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